

ABSTRACT

Ln *A.7*

ALUMINUM ALLOY STRIP MANUFACTURING PROCESS FOR THE
MANUFACTURE OF BRAZED HEAT EXCHANGERS

5

The invention relates to a process to manufacture a clad strip, < 1.5 mm thick, intended for the manufacture of brazed heat exchangers, comprising:

10 - casting of a plate made of core alloy composed as follows (% by weight):

Si < 0.8 Fe < 0.8 Cu: 0.2 - 0.9 Mn: 0.7 - 1.5
 Mg < 0.4 Zn < 0.2 Ti < 0.1 other elements < 0.05
 each and < 0.15 in total, the remainder aluminium,

15 - homogenization of said plate between 550 and 630°C for at least one hour,

- cladding on one or two sides of said blank of a brazing aluminium alloy, preferentially containing 5 to 13% silicon,

20 - hot rolling followed by cold rolling of the plated blank to a thickness close to the final thickness,

- recrystallization annealing of the strip between 300 and 400°C,

25 - strain hardening of the annealed strip to obtain a permanent deformation between 2 and 10% and the final thickness.

09987699-11501
 TOSTT-66928660